

Work Order ID 71226

Friday, June 24, 2011 11:45:28 AM



Page 1

Item ID: D3504-5

Accept



Setup Start



Revision ID:

Item Name: Crossbolt Spacer

Stop



Start Date: 6/24/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 20.00



Customer:

Reference:

W

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3504	Rev C

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA712 & DWG D3504, LIFOLIO
REV: *N/A* DWG REV: *C* 12-DEBURR AS REQUIRED

21 6

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 1106128

21 6

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

SL 1106128

21 11-6-29

21 4

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Stop



Item Name: Crossbolt Spacer

Start Date: 6/24/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location

LG

0.00



Packaging

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL

21 0 86 up 7/12

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/17/13

MF 11-0743

Picklist Print

Friday, June 24, 2011 11:45:25 AM

Page 1

Work Order ID: 71226

Parent Item: D3504-5

Parent Item Name: Crossbolt Spacer



Start Date: 6/24/2011

Required Date: 6/30/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	61.2030	0.307	0.372632	6.2	6/24/11	PT
6061-T6 Round Bar .750"													

Location

Loc Qty

Loc Code

MAT013

61.203

112442

0.796

116406

0.617

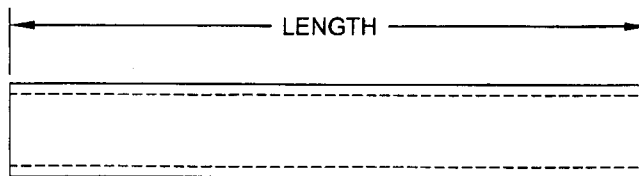
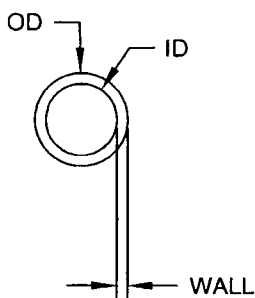
117481

35.79

118106

24

4 PT



D3504-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	LENGTH +0.030 -0.000	ID	MATERIAL SPEC	NOTE
D3504-1	0.500	0.049	3.475	0.402 (REF)	M6061T6T0.500W.049	SEE NOTE 1a)
D3504-3	0.375	0.049	3.475	0.277 (REF)	M6061T6T0.375W.049	SEE NOTE 1a)
D3504-5	0.750	0.080 (REF)	3.400	0.590	M6061T6R0.750	SEE NOTE 1b)

D3504-1/-3/-5 CROSS BOLT SPACER:

- 1) MATERIAL: a) 6061-T6 OR 6061-T62 TUBING
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6TD.DDDW.TTT)
- b) 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6R0.750)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

Handwritten signature/initials

RELEASED
07.11.16

C	ADD -5	DC	07.09.19
B	3.475 WAS 3.400	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3504	SHEET 1 OF 1
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	CROSS BOLT SPACER	NTS
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